

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SM 12/12/04

D3849-041

Job Sheet 204084



POSITIVE RECALL
EFFECTIVE ___ AUTH ___
RELEASED ___ DATE ___

Part No: D3849-041 **Job Qty:** ~~12 pcs~~ 6

Part Name: Fwd Heavy-Duty Wearplate, Std Skid Compatible



Part Weight: 0 lbs **Status:** New **Priority:** Medium

Job Created: 12/2/19 **Job Tracking No:**

Due Date: 12/18/19 **Created By:** Marie Lajeunesse

Type: SOLD **Description:**

Note: URF 19-902 DWG D3849 REV.G IPP RevA: New issue DD verified by:EC IPP Rev:B 12.09.11 AS PER DWG REV.D DD VERF:JLM IPP Rev:C 14.11.26 AS PER DWG REV.E DD VERF:JLM IPP REV:D 16.06.17 DWG REV.F DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter / Supplier Lead Time	Sign-off
110	Large Fab - Welded Assy-1	12 pcs		12/18/19	0.00	18.18	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	MV Jan 14/20
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
							Large Fab - 11 (Various)	
							Large Fab - 12	
120	QC 9	12 pcs		12/18/19	0.00	0.00	QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	i2
							QC 9 - 9	
130	QC 5	12 pcs		12/18/19	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	



Dart Aeros
1270 Aberde
Hawkesbury,
CANADA
TEL.: 1 613 6
Email: sales@
www.dartaero

ontainer No: S247415



a D3849 – 041
ob No: 204084
erial No/Batch: S247415
evision: REV.G
spector:

Plex 12/2/19 1:36 PM Dart.lajeunesse.marie

					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	a
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140 **Spray Paint - 2 - B4B**	12 pcs	12/18/19	0.00	6.00	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 20-1-15
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
150 QC 5	**12** pcs	12/18/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	JAN 16 2020 68
					QC 5 - 9	9-88
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160 **Packaging 3-1 - Stock - B4B**	12 pcs	12/18/19	0.00	0.00	Packaging 3 - 1 - B4B FP-002	JL 20-1-16
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	

Plex 12/2/19 1:36 PM Dart.lajeunesse.marie

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 **QC 21 - SA**	12 pcs	12/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

JAN 1 6 2020

Part Op Descriptions: **110** - (Weld per dwg A/R S.S. rod Batch: M136585) TRANSFER DRILL 00.188 HOLES FROM D3849-1 WEARPLATE TO D3901-041 WEARBARS,
120 - (QC9- Inspect visual per QSI004- Fusion Welds)
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Spray Paint / NDT Room) APPLY ROCKGUARD AS PER DWRG BATCH: 5242921
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Identify as per dwg & Stock Location:_______) LOCATION : FG002
170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3849-1	Plate	12 pcs (1 ea)	110-Large Fab - Welded Assy-1	5236785
D3901-041	Wearbar Weldment	24 pcs (2 ea)	110-Large Fab - Welded Assy-1	5239254

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D3849-1	12	0	0
	D3901-041	24	0	0

Part Specifications

Specifications could not be found.

Plex 12/2/19 1:36 PM Dart.lajeunesse.marie

Entered: ____________ Date: ____________



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. Route update only ☐

Job: ____________ Part No. ____________	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐	**DEPARTMENT/PROCESS** Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐

Date :	Sequence #:	QTY Affected :	**MRB (QSI042)**
Description Work Order Deviation		**Disposition**	**Completed By**
			Lead hand / Supervisor
			QC / QA Coordinator

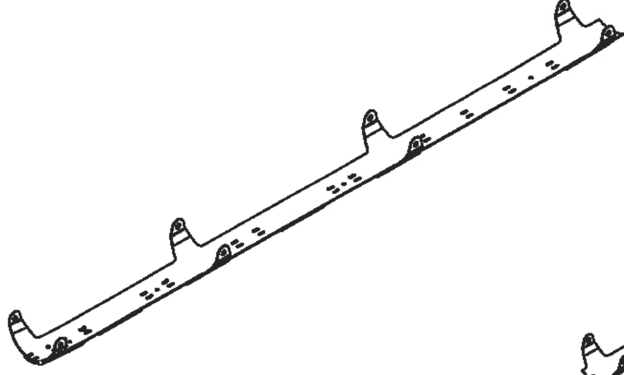
Root Cause

- Operator ☐
- Manufacturing Process ☐
- Equip/Tooling ☐
- Handling/Presservation ☐
- Material ☐
- Product Improvement ☐
- Process Improvement ☐
- Human Factors ☐

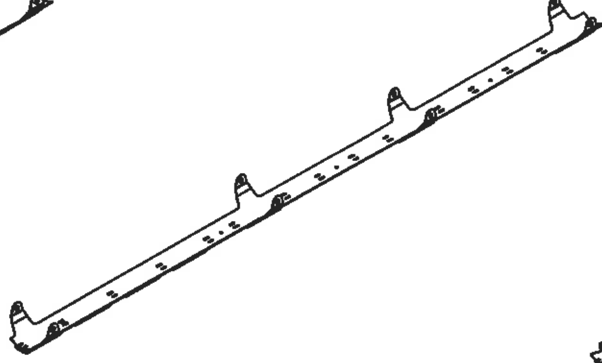
FAULT CATEGORY

☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance
☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	

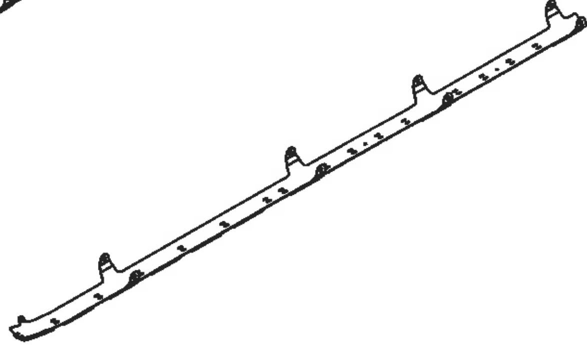
Other/Details:



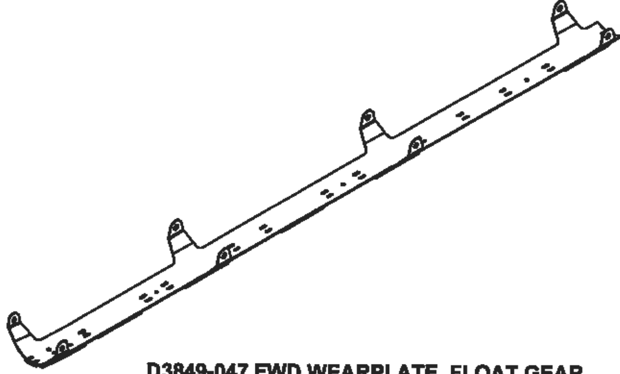
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE, FLOAT GEAR

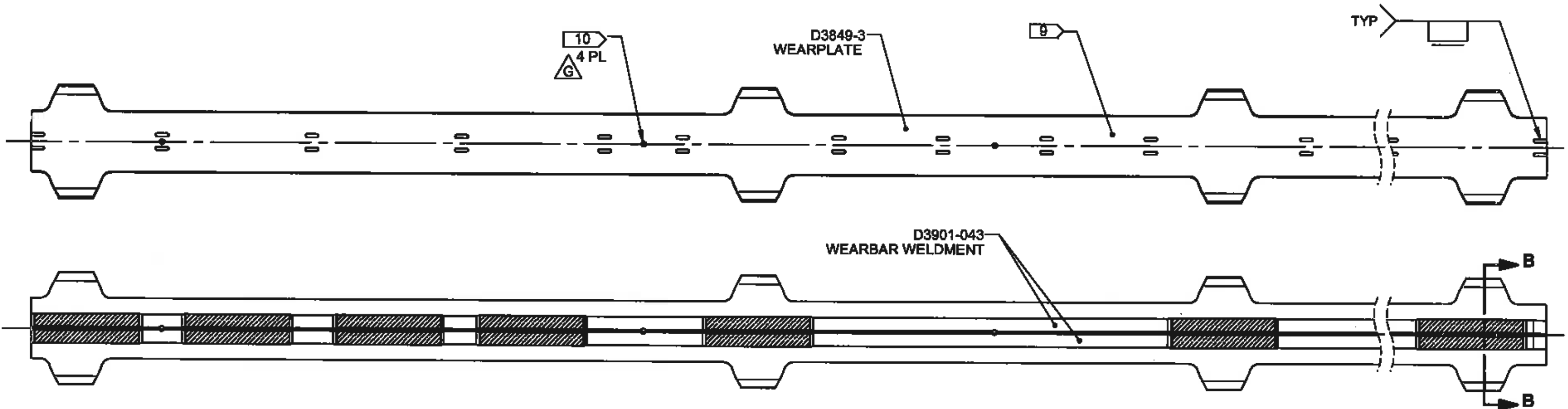
REV.	DESCRIPTION	BY	DATE
G	CHANGED WEARBAR ON -047 (D3901-047 WAS -041), ADDED SECOND WEARBAR TO D3849-041/-047, REVISED WELD SLOT/HOLE LAYOUT AND DRAIN HOLES ON D3849-1/-3/-5/-7 TO IMPROVE WELDING. REF CAR19-319. SECTIONS/DETAILS REDRAWN TO CURRENT STANDARDS. FLAT PATTERN ADJUSTED PER TEST FIT.	ZF	19.06.11
F	HARD SURFACING MOVED TO DRAWING D3901 FOR AUTOMATED WELDING. ALL VIEWS UPDATED ACCORDINGLY. SHT 6 FLAT PATTERN VIEW DIM 54.45 WAS 54.26, DIM 51.50 WAS 51.31 ADD 15.50 REF DIM. SHT 7 FLAT PATTERN VIEW B3-B2 CHANGED SLOT PITCH. UPDATE NOTES ALL SHEETS.	AJS	16.01.05
E	TEXTURED COATING WAS 4714 ROCKGUARD (BOM TABLE), CHANGE NOTE 10 (SH 2, 3, 4, 5), 8.49 LBS WAS 7.66 LBS (SH 3, NOTE 7), 10.25 LBS WAS 8.93 LBS (SH 4, NOTE 7), 4.66 LBS WAS 4.60 LBS (SH 5, NOTE 7)	AK	14.06.07
D	REVISED FLAT PATTERN - CHANGED SLOT LOCATIONS TO MATCH D3901-1/-3/-5 BARS (ZN B6-6, B3-6, B6-7, C2-7, B6-8, B2-8, B7-9, 32-9).	DC	12.06.23
C	REVISED FLAT PATTERN - CHANGE SLOT LOCATIONS, ADDED DOUBLE SLOTS AND D3901-3/-5 BARS ON -043/-045. UPDATED DETAIL VIEWS. CHANGED WELD DETAILS (ZN B2-2). REMOVED D3848-1/-3/-5/-7 GASKETS, ADD ROCKGUARD COATING, REMOVE FINISH.	DC	12.06.21
B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F/-3F/-5F (ZN A4-5,B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/-7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C6-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A6-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.36 (ZN B4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30

RELEASED

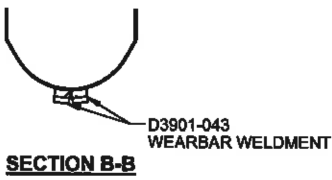
DESIGN	RF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. D3849	REV. G SHEET 1 OF 10
MFG. APPR.	DD		
APPROVED	NO	TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.	DS		
DATE	19.06.11		

COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

QTY -043	P/N	DESCRIPTION
X	D3849-043	AFT WEARPLATE ASSY, STD GEAR
1	D3849-3	WEARPLATE
2	D3901-043	WEARBAR WELDMENT



D3849-043 AFT WEARPLATE ASSY, STD GEAR



SECTION B-B

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
(G) 7) WEIGHT: 9.01 lbs
8) WELDING: PER QSI 004
9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9.
10) TRANSFER DRILL Ø0.188 HOLES FROM D3849-3 WEARPLATE TO D3901-043 WEARBARS, AFTER APPLYING TEXTURED COATING.

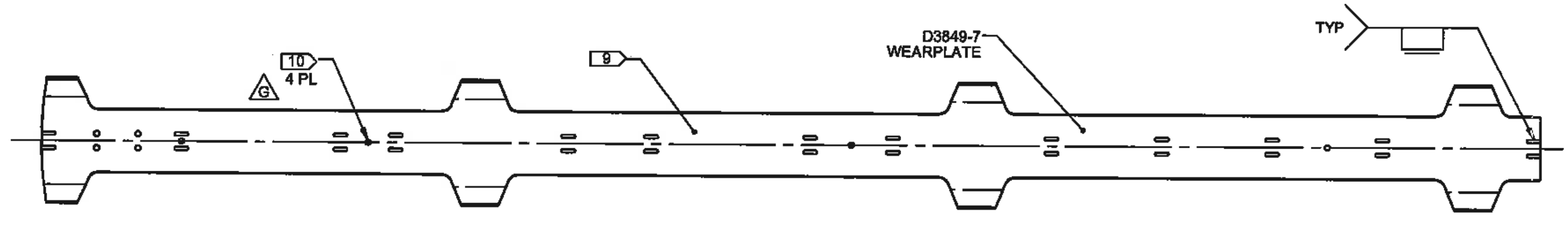
RELEASED

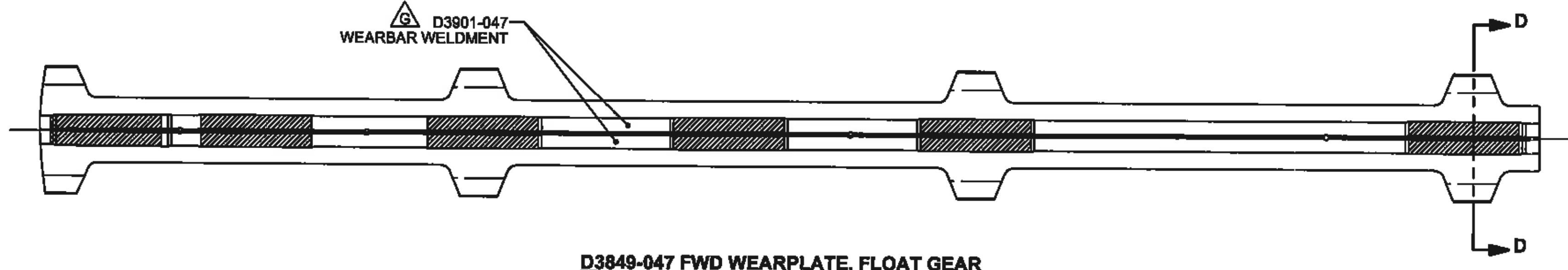
DESIGN	RF	DART AEROSPACE USA, INC. HILLSBORO, OR
DRAWN	ZF	
CHECKED	MW	DRAWING NO. D3849 REV. G SHEET 3 OF 10
MFG. APPR.	DD	
APPROVED	NO	TITLE WEARPLATE ASSY SCALE NTS
DE APPR.	DS	
DATE	19.06.11	

COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

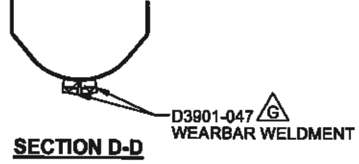
QTY -047	P/N	DESCRIPTION
X	D3849-047	FWD WEARPLATE, FLOAT GEAR
1	D3849-7	WEARPLATE
2	D3901-047	WEARBAR WELDMENT

G





D3849-047 FWD WEARPLATE, FLOAT GEAR



SECTION D-D

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
G 7) WEIGHT: 7.45 lbs
8) WELDING: PER QSI 004
9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9.
10) TRANSFER DRILL Ø0.188 HOLES FROM D3849-7 WEARPLATE TO D3901-047 WEARBARS, AFTER APPLYING TEXTURED COATING

RELEASED

DESIGN	RF	DART AEROSPACE USA, INC. HILLSBORO, OR
DRAWN	ZF	
CHECKED	MW	DRAWING NO. D3849 — REV. G — SHEET 5 OF 10
MFG. APPR.	DD	
APPROVED	NO	TITLE WEARPLATE ASSY — SCALE NTS
DE APPR.	DS	
DATE	19.06.11	

COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



D3849-3 WEARPLATE
(MAKE FROM D3849-3F)



G D3849-3F FLAT PATTERN

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5059 OR AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
G 7) WEIGHT: 2.73 lbs

RELEASED

DESIGN	RF	DART AEROSPACE USA, INC. HILLSBORO, OR
DRAWN	ZF	
CHECKED	MW	DRAWING NO. D3849 — REV. G
MFG. APPR.	DD	SHEET 7 OF 10
APPROVED	NO	TITLE — SCALE
DE APPR.	DS	WEARPLATE ASSY — NTS
DATE	19.06.11	

COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.





NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5059 OR AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
G 7) WEIGHT: 2.29 lbs

RELEASED

DESIGN	RF	DART AEROSPACE USA, INC. HILLSBORO, OR
DRAWN	ZF	
CHECKED	MW	DRAWING NO. D3849 — REV. G — SHEET 9 OF 10
MFG. APPR.	DD	
APPROVED	NO	TITLE WEARPLATE ASSY — SCALE NTS
DE APPR.	DS	
DATE	19.06.11	

COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.